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Abstract

Stop

[illegible]

Abstract

Reference:

Date: 11-05-09

Tooling:

Date:

Run Start

[illegible]**Date:**

SPC (Y/N):

Date:

Stop

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Draw Nbr	Revision Nbr	
DSI 9500	A	

0,00

Abstract

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI9500-011
CHG001

XMF 11-05-09

Hyder BG 11-5-a

110

Pick Kit

0.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Packaging

Memo

0.00

Packaging

Page 2

120

QC4- 100% Inspect kits for completeness

0.00

[illegible]

QC

Memo

0.00

Quality Control

8/11/09

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69329

Monday, May 09, 2011 10:09:20 AM



Page 2

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI9500-011

Location:

PPP rev:

*20 Draft**11/5/95 (20)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/5/95**MF**1105-09*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 09, 2011 10:09:16 AM

Page 1

Work Order ID: 69329

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7 Mounting Lug		Manufactured	No			110	Each	79.0000	2	4			

Location	Loc Qty	Loc Code
ST470	79	
59202	4	
61653	2	
62929	41	
66427	32	

D2732-030 Rubber Cushion		Manufactured	No			110	Each	12.0000	8				
-----------------------------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

Location	Loc Qty	Loc Code
ST410	12	
56516	10	
65395	2	

D3394-043 Lug Assembly		Manufactured	No			110	Each	100.0000	2	4			
---------------------------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST475	100	
52331	4	
62005	2	
62930	30	
62976	30	
66429	34	

82

11X

82

82

02732

→ measure
81105109

59202

16 4P161
64223

1410/8 (2)

52331

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 09, 2011 10:09:16 AM

Page 2

Work Order ID: 69329

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

D4064-041

Manufactured No

110

Each

33.0000

1

2



Mounting Lug

Location

Loc Qty

Loc Code

ST462

18

62977

18

ST464

15

58980

14

58985

1

58980

AN4C13A

Purchased

No

110

Each

32.0000

4

8



BOLT

Location

Loc Qty

Loc Code

ST353

7

117366

7

ST357

25

117619

25

M117366 7x

M117619 1x

AN4C14A

Purchased

No

110

Each

86.0000

4

8



Bolt

Location

Loc Qty

Loc Code

ST357

80

117366

40

117441

40

ST358

6

115767

4

115936

2

M117441 6x / 115936 2x

M115936 2x

Monday, May 09, 2011 10:09:17 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 09, 2011 10:09:17 AM

Page 3

Work Order ID: 69329

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C15A

Purchased

No

110

Each

103.0000

4

8



Bolt

Location

Loc Qty

Loc Code

ST358

103

115936

43

117441

60

115936

AN960C416

NAS1149C0463

Purchased

No

110

Each

15.0000

16

32



washer

Location

Loc Qty

Loc Code

ST346

15

100993

15

100993 15x

AN960C416L

NAS1149C0463

Purchased

No

110

Each

0.0000

8

16



WASHER

NAS1515H4L

Purchased

No

110

Each

556.0000

24

48



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST266

20

114265

20

ST277

496

117363

496

117363

Monday, May 09, 2011 10:09:17 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Picklist Print

Monday, May 09, 2011 10:09:17 AM

Page 4

Work Order ID: 69329



Parent Item: DSI 9500-011



Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

110

Each

1,522.000

12

24



Nut



Per 10/9 (2)

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST300	600	
117423	600	
ST301	882	
114523	3	
116188	79	
116549	300	
117601	500	

116188

Monday, May 09, 2011 10:09:17 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE

REF TCCA STC: SH98-14

REF EASA STC EASA.IM.R.S.01339

REFERENCE ONLY

PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CHANGE:

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG
2	2					D2731-7	MOUNTING LUG
2	2					D3394-041	MOUNTING LUG
2	2					D3394-043	MOUNTING LUG
16	16					AN960C416L	WASHER

IS:

4	4					D2731-7	MOUNTING LUG
4	4					D3394-043	MOUNTING LUG
1	1					D4064-041	MOUNTING LUG (NEW)
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET
16	16					AN960C416	WASHER

* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE USA, INC	
DRAWN	92	PORT HADLOCK, WA	
CHECKED	3	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 1 OF 4
APPROVED	#	TITLE	SCALE
DE APPR.	#	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

THE DSI-9500-011 LUG UPGRADE KIT IS AVAILABLE TO UPDATE EXISTING D206-628-013/-014 STEPS TO CHANGE 006. THE UPGRADE KIT INCLUDES ADDITIONAL LUGS FOR STEPS INSTALLED WITH APICAL TRI-BAG FLOATS (AT 17.25" HEIGHT). EXISTING D206-628-013/-014 STEPS INSTALLED WITH OEM FLOATS (AT 15.00" HEIGHT) DO NOT REQUIRE THE KIT. THE UPGRADE KIT SHOULD BE INSTALLED PER THIS SERVICE INSTRUCTION AND IIN-D206-628 REV. F.

QTY -011	Part Number	Description
X	DSI-9500-011	LUG UPGRADE KIT, 206 A/B FLOAT STEP
2	D2731-7	MOUNTING LUG (REPLACES D2731-3 MOUNTING LUG)
8	D2732-030	RUBBER CUSHION
2	D3394-043	MOUNTING LUG (REPLACES D3394-041 MOUNTING LUG)
1	D4064-041	MOUNTING LUG (REPLACES ONE D3394-043 FOR APICAL TRI-BAG FLOAT COMPATIBLE INSTALL)
4	AN4C13A	BOLT
4	AN4C14A	BOLT
4	AN4C15A	BOLT
16	AN960C416	WASHER
8	AN960C416L	WASHER
24	NAS1515H4L	WASHER
12	MS21043-4	NUT

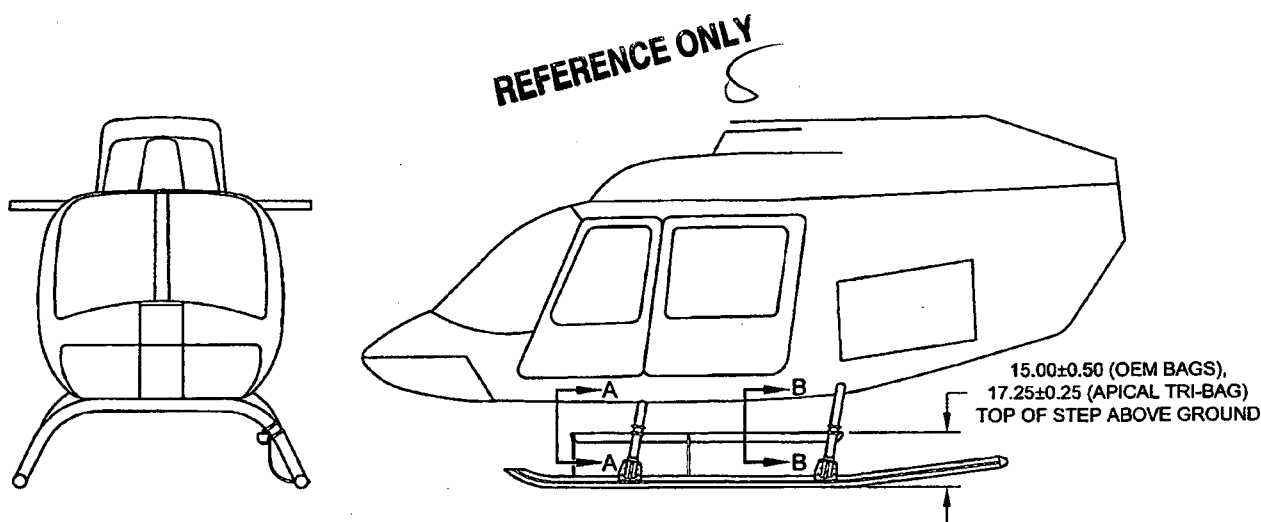
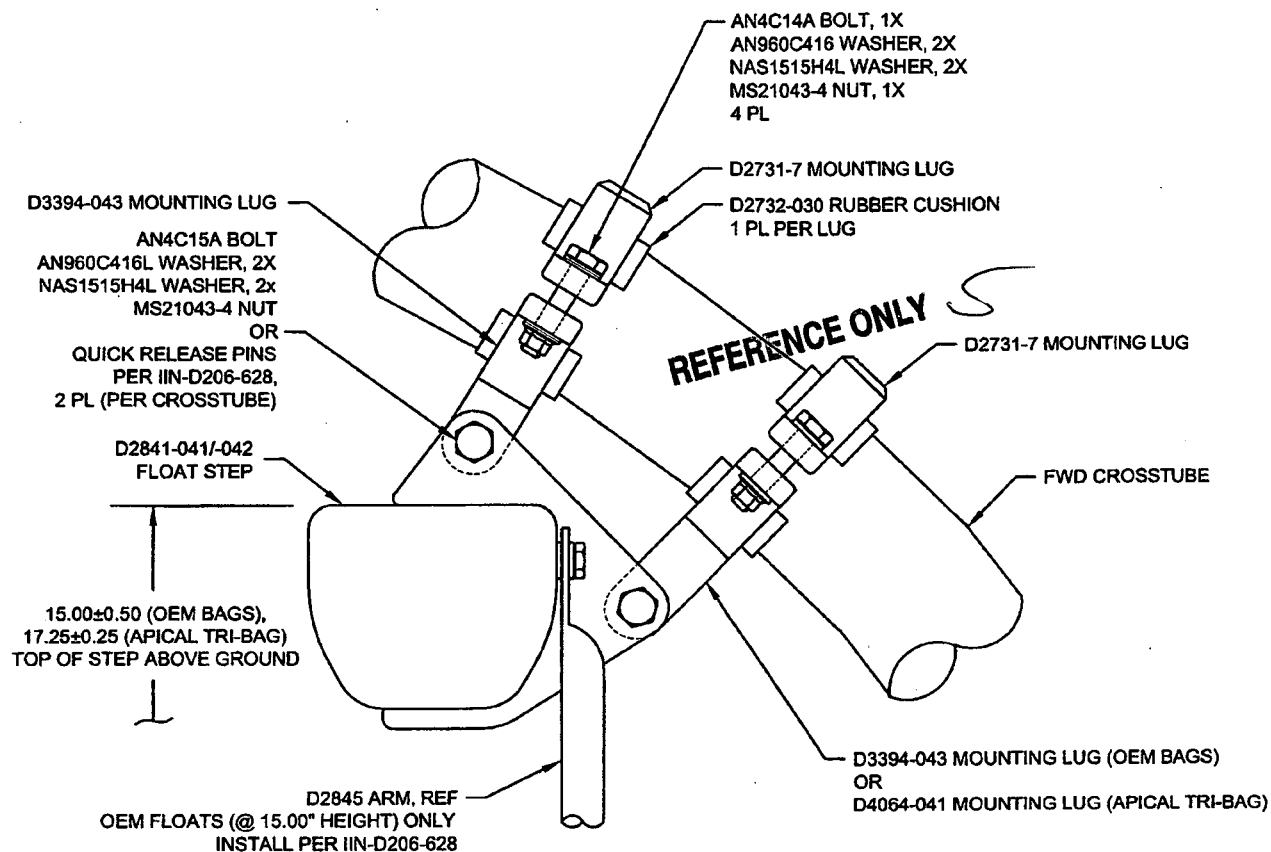


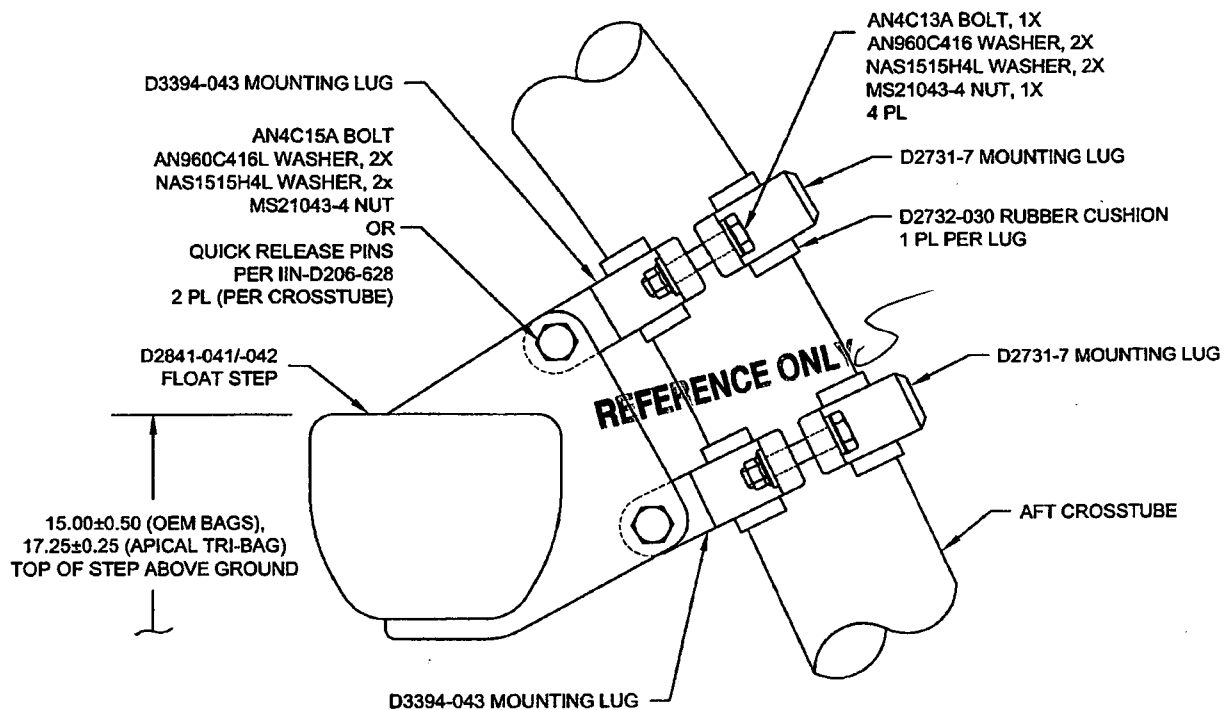
FIGURE 1
D206-628-013 (SHOWN) / -014 (OPPOSITE)
206 A/B FLOAT STEP INSTALLATION

DESIGN	9P	DART AEROSPACE USA, INC	
DRAWN	9P	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG CHANGE	NTS
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SECTION A-A
FWD CROSSTUBE CLAMPING DETAIL

DESIGN	<i>gp</i>	DART AEROSPACE USA, INC	
DRAWN	<i>gp</i>	PORT HADLOCK, WA	
CHECKED	<i>h</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9500	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG CHANGE	NTS
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SECTION B-B
AFT CROSSTUBE CLAMPING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	11	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 4 OF 4
APPROVED	11	TITLE	SCALE
DE APPR.	11	MOUNTING LUG CHANGE	NTS
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